

**Work Order ID 69142**

Tuesday, May 03, 2011 10:54:22 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-05-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 1115778 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A  
2- weld hinge (3) and Mounting brackets as per dwg D3914  
\*\*\*inspect before welding mesh\*\*\*  
3- tack weld mesh on basket as per dwg D3914  
\*\*\*make sure to place mesh correctly on lid, check with label plate before  
tacking mesh\*\*\*

11-05-10 (10)

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-05-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\* mask sides of hinge prior to powdercoat\*\*\*

Start Time: 7:50

Oven Temperature: 320 °F

Finish Time: 8:20

140

Wing Walk as per dwg QSI005 4.4 Batch

0.00



HandFinish

Memo

0.00

Hand Finishing

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg

2- Install placard and label as per dwg

\*\*\*Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label \*\*\*

M115128

M117315

IX ~~Ø~~ M-L 11/05/11IX ~~Ø~~ M-L 11/05/11

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Start Date: 5/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 5/9/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00				1	BR	11-5-11	
160 	Identify as per dwg & Stock Location <u>GA</u>	0.00							
Packaging Packaging	Memo <u>u/p 69132</u>	0.00							<u>ES 11/05/11</u>
170 	QC21- Final Inspection - Work Order Release	0.00							
QC Quality Control	Memo	0.00							<u>11/5/11</u> <u>ME</u> <u>11-05-11</u>

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 03, 2011 10:54:31 AM

Page 1

Work Order ID: 69142

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2581  Mounting Bracket		Manufactured	No			100	Each	12.0000	2	2			
---------------------------------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA005	12	
66806	12	

~~B68964~~ (2x) NY 11.05.06

* D3914-1  Rib		Manufactured	No			100	Each	0.0000	2	2			
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

~~B66979~~ (2x) NY 11.05.06

✓ D3914-7  Rib		Manufactured	No			100	Each	6.0000	2	2			
----------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	1	
66620	1	
WA006	5	
66980	1	
68175	4	

(1x)  
(1x)

✓ D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	6.0000	3	3			
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~~B65951~~ NY 11.05.06

Location	Loc Qty	Loc Code
WA005	6	
67040	6	

(3x)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





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**NOTE:** Date & initial all entries

# Picklist Print

Page 3

Tuesday, May 03, 2011 10:54:32 AM

Work Order ID: 69142



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2011

Required Date: 5/9/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-043 Manufactured No

100

Each

7.0000

1

1



Lid Rib Assembly, Aft (350 Basket)

*NY 11-05-06*

Location

Loc Qty

Loc Code

WA006

7

67336

1

67375

6



D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label

*G*

*EF 5/05/11*

Tuesday, May 03, 2011 10:54:32 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE

**D3914-041 LONG BASKET LID ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 69142

PL11-05-3

**RELEASED**  
10.08.17  
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	MS		
APPROVED	MS		
DE APPR.	MS		
DATE	10.08.05		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3914** REV. B  
SHEET 1 OF 4  
TITLE **LONG BASKET LID ASSY (350)** SCALE NTS

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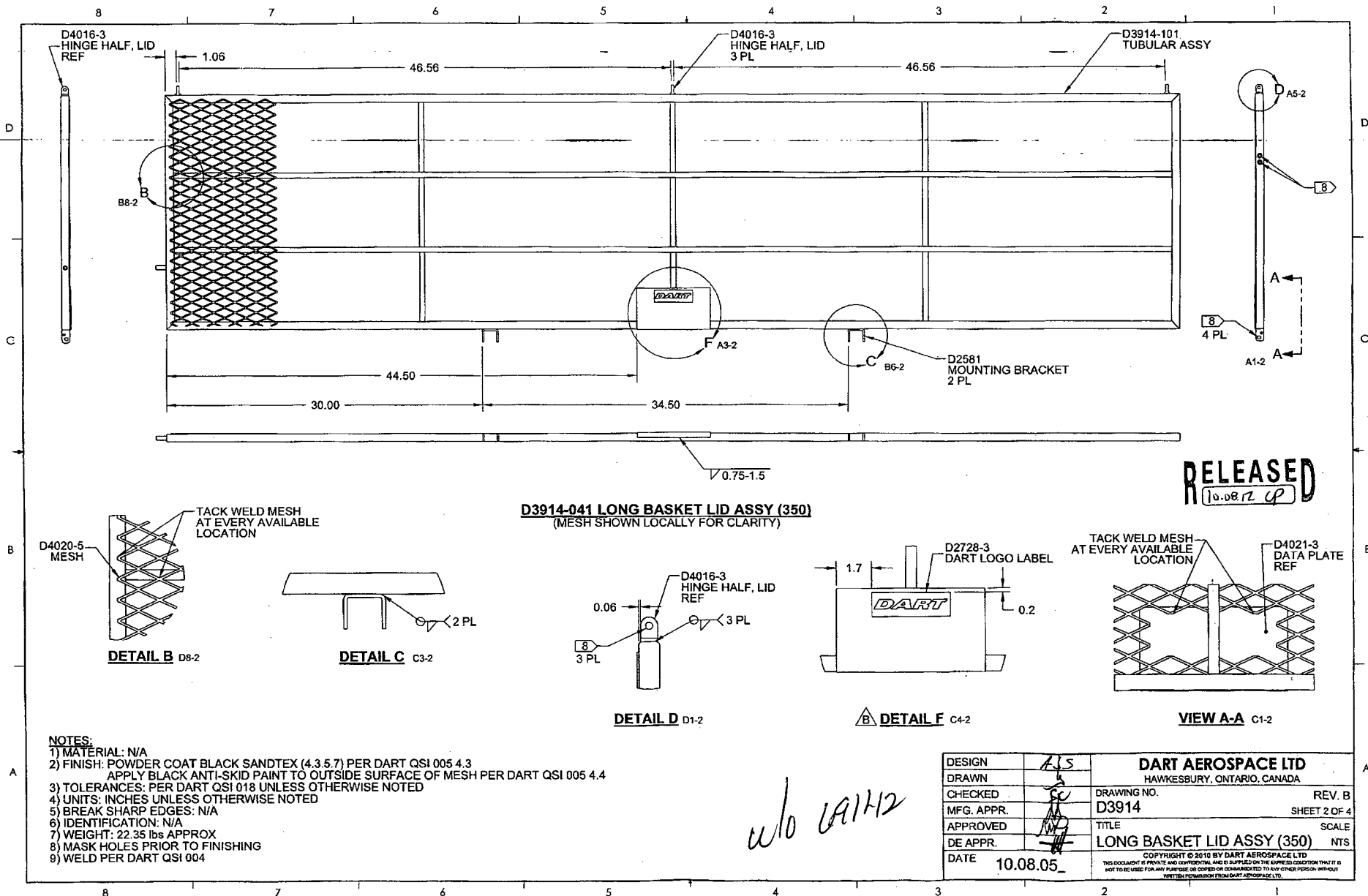
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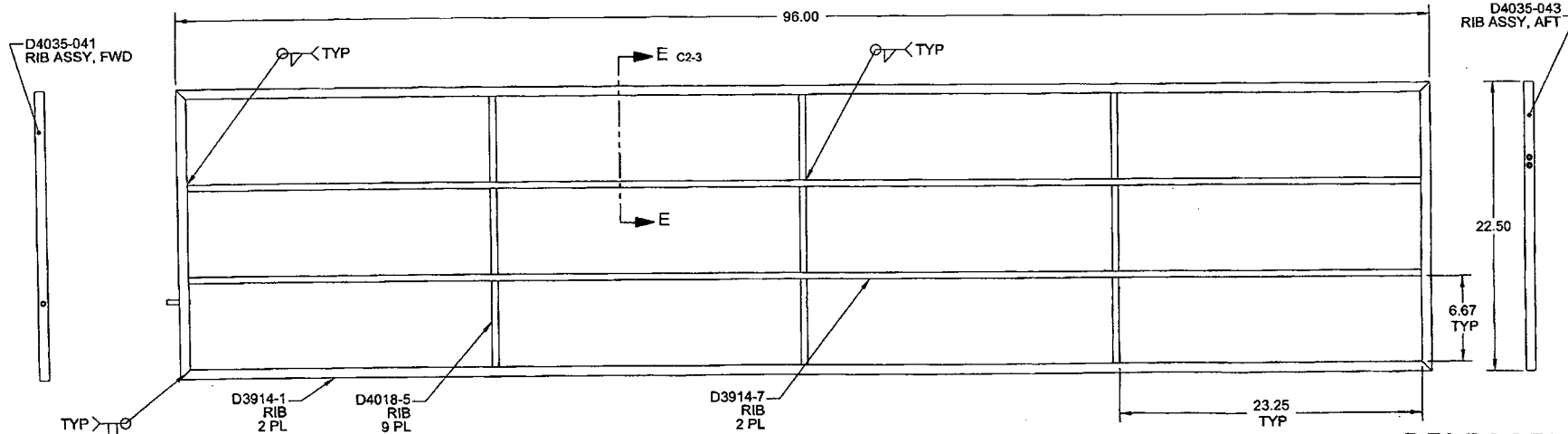
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E CS-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED  
10-08-05

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D4018-101
- 9) WELD PER DART QSI 004

*WLB 10/14/05*

DESIGN	ALS	DART AEROSPACE LTD	REV. B
DRAWN	TC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	TC	DRAWING NO. D3914	SHEET 3 OF 4
MFG. APPR.	TC	TITLE	SCALE
APPROVED	TC	LONG BASKET LID ASSY (350)	NTS
DE APPR.	TC	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.08.05	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

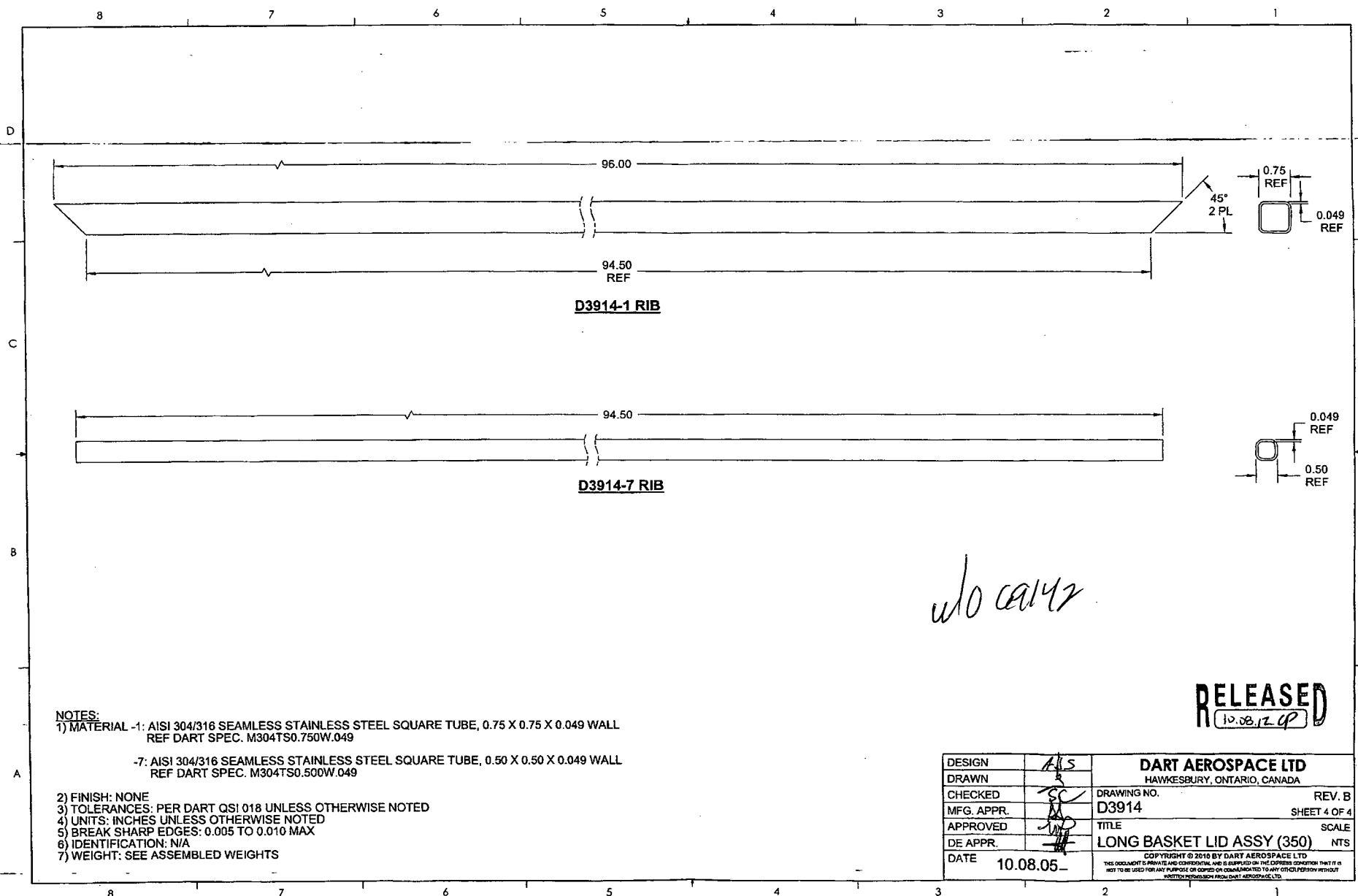
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W/O 00142

RELEASED  
10.08.12 GP

**NOTES:**

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D3914	SHEET 4 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	LONG BASKET LID ASSY (350)	NTS
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